

# Work Order ID 94073

\*94073\*

Page 1

November-30-12 8:33:37 AM

Item ID: D205-765-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Driveshaft Tunnel

Start Date: 11/30/12 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-12-03

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN D205-765	Rev A								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPd205-765								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten:* 12-12-12 (2)

*Handwritten:* 12/14/12 (2)

*Handwritten:* 12/17

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
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Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

# Work Order ID 94073

**\*94073\***

Page 2

November-30-12 8:33:37 AM

Item ID: D205-765-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Driveshaft Tunnel

Start Date: 11/30/12 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	PACKAGE PER PPP								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
20  
9-09

12-12-18

12-12-18

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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# Picklist Print

November-30-12 8:33:36 AM

Page 1

Work Order ID: 94073

Parent Item: D205-765-011

Parent Item Name: Driveshaft Tunnel

Start Date: 11/30/12

Required Date: 12/14/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-03-17 JLM Verified By: LL  
\*\*\*\*\*MS20427M4 rivets are supplied by customer\*\*\*\*\*

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>AN3CSA</b> Bolt		Purchased	No			110	Each	231.0000	17	34	124028		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		38							
				118352		38							
				ST350		193							
				120187		1							
				123203		192							
<b>D3648-041</b> Driveshaft Tunnel Assembly		Manufactured	No			110	Each	0.0000	1	B 9438 2 SP			
<b>D3654-1</b> Doubler		Manufactured	No			110	Each	7.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST188		7							
				90625		7							
<b>D3682-1</b> Gasket		Manufactured	No			110	Each	6.0000		2	90625		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST188		6							
				90391		6							
<b>NAS1049G0363R</b> Washer		Purchased	No			110	Each	4,203.0000	17	34	90391		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST292		4203							
				114742		2003							
				122063		200							
				122441		2000							

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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JMD

## 5. PARTS LIST

Qty -011	Part Number	Description
X	D205-765-011	DRIVESHAFT TUNNEL KIT
<del>1</del>	<del>D3648-041</del>	<del>TUNNEL ASSEMBLY</del>
1	*D3649-041	TUNNEL BOTTOM PANEL ASSY.
1	**D3649-1	TUNNEL BOTTOM PANEL
22	**MS21060-3K	NUTPLATE
22	**MS21062-3K	NUTPLATE
88	**MS20427M3-3	RIVET
1	*D3650-041	TUNNEL TOP PANEL ASSY.
1	**D3650-1	AFT PANEL
1	**D3650-3	CENTER PANEL
1	**D3650-5	FWD PANEL
8	**AN3C-3A	BOLT
8	**AN960C10	WASHER
1	*D3651-041	AFT BASE ASSEMBLY
1	**D3651-043	FLANGE WELDMENT
1	**D3651-1	GASKET
1	**D3651-9	INSIDE DOUBLER
1	**D3651-11	GASKET
1	**D3651-13	OUTSIDE DOUBLER
58	**CR3523-4-02	RIVET
40	*AN3C-3A	BOLT
40	*AN960C10	WASHER
<del>1</del>	<del>D3654-1</del>	<del>DOUBLER</del>
<del>1</del>	<del>D3682-1</del>	<del>GASKET</del>
<del>17</del>	<del>AN3C-3A</del>	<del>BOLT</del>
<del>17</del>	<del>AN960C10</del>	<del>WASHER</del>
A/R	MS20427M4	RIVET

\* PART IS INCLUDED WITH D3648-041 TUNNEL ASSEMBLY

\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: A

Date: 08.01.14

W

Description: DRIVESHAFT TUNNEL[illegible]